

# Work Order ID 67771

Wednesday, March 30, 2011 10:30:32 AM



*End of this work*  
Page 1

Item ID: PB67-43001-127

Accept



Setup Start



Revision ID:

Item Name: Handle Arm

Stop



Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MF* Date: *11-03-20*

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

B67-43001

C

100



Mill Conv

Conventional Milling Machine

Manufacture as per dwg

CONVENTIONAL MILLING MACHINE

0.00

Memo

0.00

1- Mill as per Dwg B67-43001  
2- Deburr

*11/03/30*

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*11/03/30*

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

*11/03/30*

*1 0*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date

**NOTE:** Date & initial all entries

[illegible]

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**Accept**

[REDACTED]

**Setup Start**

\_\_\_\_\_

**Stop**

**Abstract**

**Cust Item ID:**

[REDACTED]

**Customer:**

**Reference:**

Run Start

**Abstract**

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop**

**Abstract**

## Insp. Stamp

0.00

**Abstract**

## Small Fab

## Memo

0.00

## Small Fab

1- chamfer as per dwg

~~A~~ 11/03/30

0.00

\_\_\_\_\_

QC

QC5- Inspect part completeness to step on W/O

0.00

## Quality Control

## Memo

8463/30

16

0.00

[illegible]

### Packaging

Identify as per dwg & Stock Location:

0.00

### Packaging

## Memo

11/3/30 DSD

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67771**

Wednesday, March 30, 2011 10:30:33 AM



Page 3

Item ID: PB67-43001-127

Accept



Setup Start



Revision ID:

Stop



Item Name: Handle Arm

Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/31

ME  
11-03-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 30, 2011 10:30:30 AM

Page 1

Work Order ID: 67771



Parent Item: PB67-43001-127



Parent Item Name: Handle Arm

Start Date: 3/29/2011

Required Date: 3/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 05.07.20 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.875W0.12 5		Purchased	No			100	f	36.0000	0.525	0.552632			



6061-T6 RD TUBE .875 X .125W

Location

Loc Qty

Loc Code

MAT015

36

110001

36

+60 f *JA* 11/03/30

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries



Ø0.88  
REF

0.125  
REF

0.06 X 45°  
CHAMFER

6.25

6.05  
REF

R0.44

# **B67-43001-127 HANDLE ARM**

**RELEASED**  
2009-09-24

## **NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING  
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR  
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8  
REF. DART SPEC. M6061T6T0.875W.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 LBS

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 35 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.26
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS			
CHECKED	AS	DRAWING NO.	REV. C	
MFG. APPR.	M	<b>B67-43001-127</b>	SHEET 1 OF 1	
APPROVED	MP	TITLE	SCALE	
DE APPR.	N/A	<b>HANDLE ARM</b>	NTS	
DATE	09.02.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

W/O:		WORK ORDER CHANGES						
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